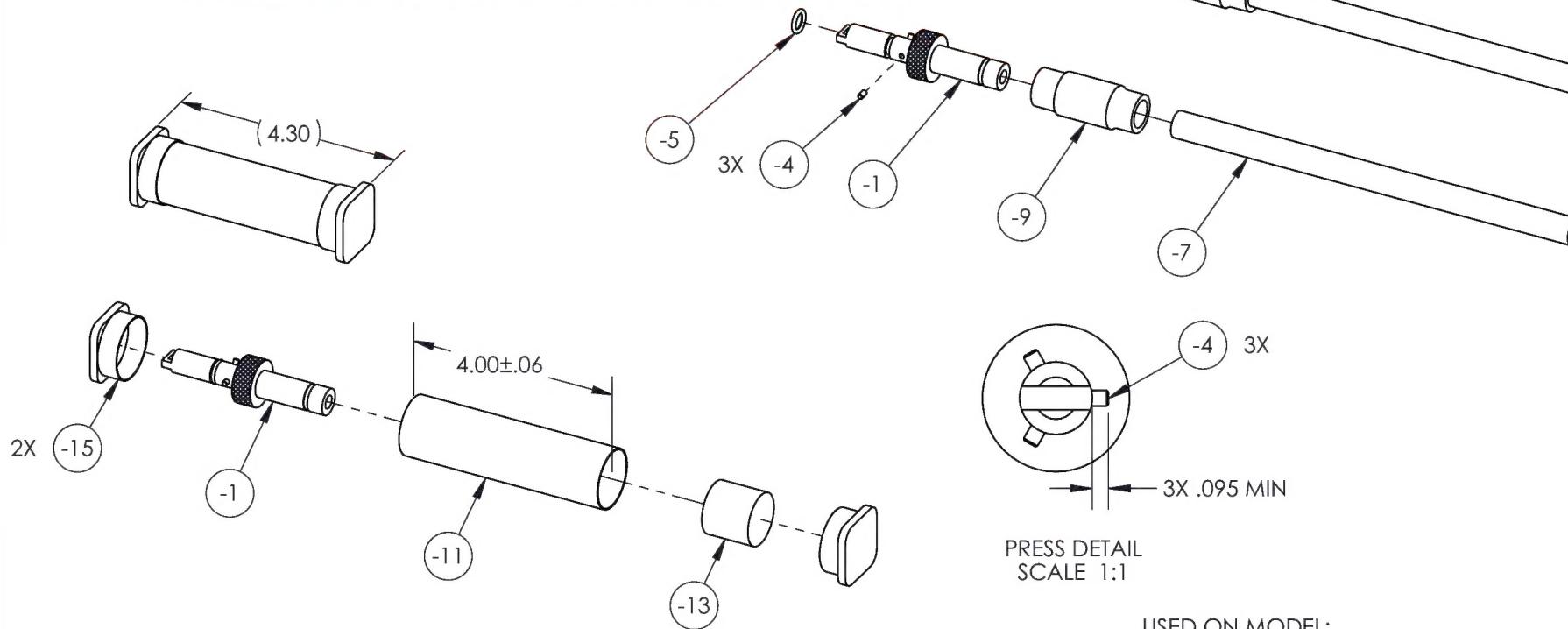


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REVISIONS					
REV	DESCRIPTION	DATE	INITIAL	APPROVED	
1	CHANGED P/N FROM DB3703-30	4/21/2006	COLE	APPROVED	
2	IMPLEMENTED NEW DWG FORMAT. DELETED -3 FERRAL & TWO OF -1 HOSE RIBS. REDUCED FROM TWO PAGES TO ONE. ADDED ASSY DRAWING.	5/19/2008	WP	DW	
3	CH'D CENTER HOLE FROM Ø .225 TO Ø .250. CH'D .065 DIM TO .070 ON -1 PER GE. ADDED HEAT SHRINK TO BOM & LABEL NOTE ON ASSY.	2/10/2010	RJC	RW	
4	MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, DELETED HOSE CLAMP AND HEAT SHRINK TUBE. ADDED -11, -13, -15, EXPLODED VIEW AND UPDATED BOM.	8/1/2012	JAG		
4A	-11 CH'D DIM WAS 4.10 IS 4.00. -13 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD	RW	

SEE ATTACHED DEVIATION



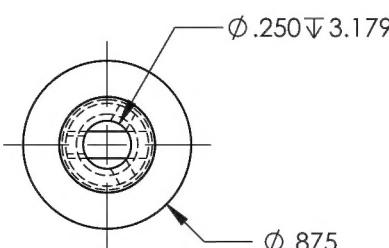
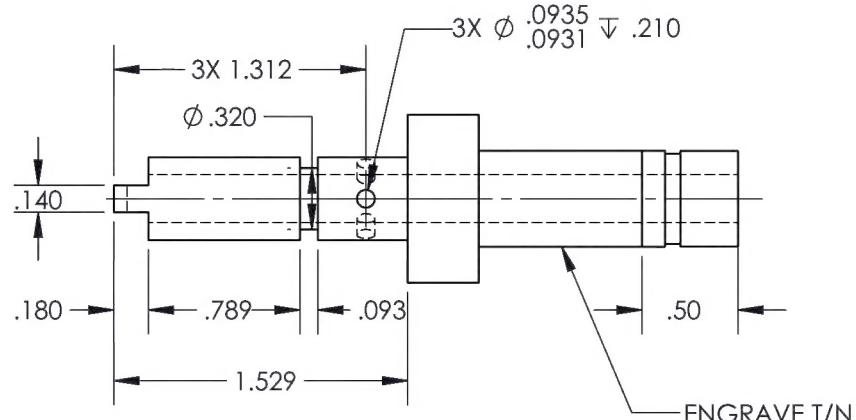
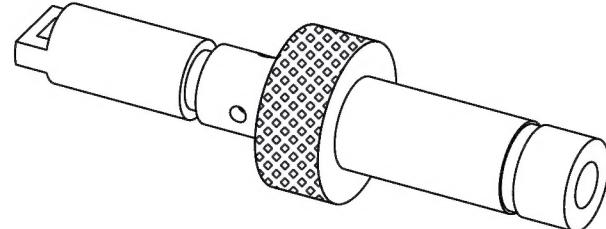
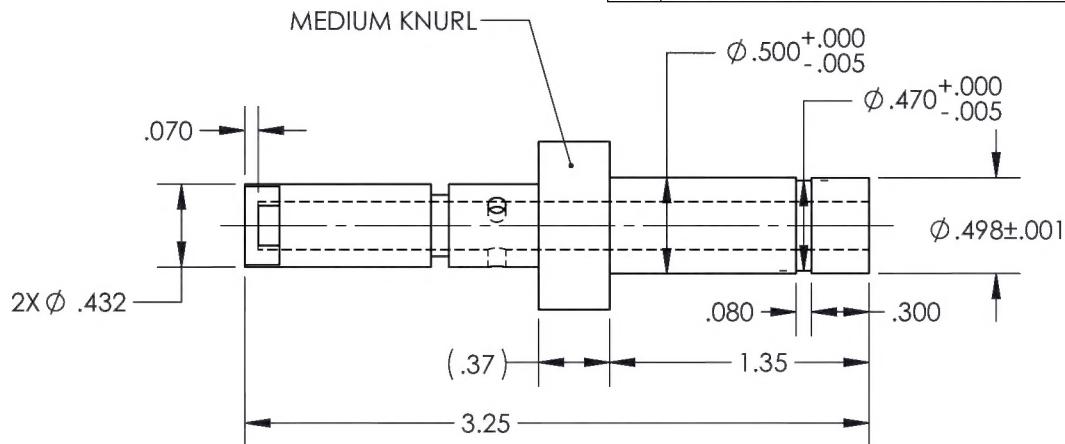
USED ON MODEL:
BELL 205-212, B3703 CHIP DETECTOR

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	Ø7/8 X 3-3/8	2
		B/O	-4	3	DOWEL PIN	S.S.	Ø3/32 X 3/16 MCMASTER-CARR #90145A433	1
		B/O	-5	1	O-RING	VITON	2-011N70 OR MCMASTER-CARR #9263K642	1
		B/O	-7	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMASTER-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYENE	Ø1.09 MCMASTER-CARR #2044T47	1
		B/O	-13	1	FOAM	POLYESTER/POLYURETHANE	Ø1 X 1 NEW PIG CORP. #PAD210	1
		B/O	-15	2	CAP	VINYL	Ø1.09 MCMASTER-CARR #2044T67	1

RED BARN MACHINE		
TITLE		
DWG NO.		REV
RBT18547		4A
MATT'L	DRAWN BY:	COLE
APPROVED <i>D Weil</i>		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
.XXX ± .005 FRACTIONS ± 1/32		
XX ± .01 ANGLES ± 5°		
X ± .1		
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
USED ON MODEL		
SEE NOTE		
SCALE	1:3	DATE
2/5/2003		SHEET 1 OF 2

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CHANGED P/N FROM DB3703-30	4/21/2006	COLE APPROVED
2	IMPLEMENTED NEW DWG FORMAT. DELETED -3 FERRAL & TWO OF -1 HOSE RIBS. REDUCED FROM TWO PAGES TO ONE. ADDED ASSY DRAWING.	5/19/2008	WP DW
3	CH'D CENTER HOLE FROM ϕ .225 TO ϕ .250, CH'D .065 DIM TO .070 ON -1 PER GE. ADDED HEAT SHRINK TO BOM & LABEL NOTE ON ASSY.	2/10/2010	RJC RW
4	INCREASED STEM LENGTH FROM .81 TO 1.35 TO WORK WITH COUPLING, DELETED BARB, ADDED GROOVE.	8/1/2012	JAG



(-1)

BODY

SEE ATTACHED DEVIATION

RED BARN MACHINE	
TITLE T/R GEAR BOX DRAIN TOOL	
DWG NO.	REV
RBT18547-1	4A
MATL 6061	DRAWN BY: COLE
APPROVED <i>D Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 ANGLES ± .5°	
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC MIL-A-8625F, TYPE II, CLASS II	
USED ON MODEL	
SEE SHT 1	
SCALE 1:2	DATE 2/5/2003
SHEET 2 OF 2	

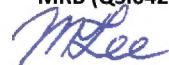
Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____	DISPOSITION	DEPARTMENT/PROCESS																																	
Part No. RBT18547 Rev. 4a	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is	<input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab	<input type="checkbox"/> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing	<input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging	<input type="checkbox"/> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality																														
Date : _____	Sequence #: _____	QTY Affected : _____				MRB (QSI042)  Oct 30, 2018																													
Description Work Order Deviation		Disposition																																	
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)		Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable). This deviation is acceptable. The fit, form and function of the part will be as originally intended.				Completed By Lead hand / Supervisor QC / QA Coordinator																													
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Preservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input checked="" type="checkbox"/> X Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Pressure/Forced</td> <td style="width: 25%;">Contamination</td> <td style="width: 25%;">Power Loss/Surge</td> <td style="width: 25%;">Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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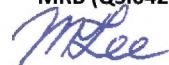
Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____	DISPOSITION	DEPARTMENT/PROCESS																																	
Part No. RBT18547 Rev. 4a	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is	<input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab	<input type="checkbox"/> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing	<input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging	<input type="checkbox"/> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality																														
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